

AERO Design Ltd.  
2013 - 39<sup>th</sup> Ave. NE  
Calgary, AB, T2E 6R7

AUTHORIZED RELEASE CERTIFICATE

TRANSPORT CANADA  
TCCA 24-0078  
AMF # 73-04

Product: Auxiliary Step Part #: 62320-01  
Approval #: SH00-48 Serial #: --  
WO #: 2006-12 Quantity: 1  
Eligibility: Bell 260L / 407 Work Status: Manufactured  
Remarks: Including liner and mounting hardware

*I hereby certify that the product identified above has been manufactured in accordance with the applicable design data and the Canadian Aviation Regulations or applicable foreign regulations.*

June 4/07  
Date

Jeff Clarke  
Inspector's Signature

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Sept 27/06  
Date

[Signature]  
Inspector's Signature

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Date

Jeff Clarke  
Inspector's Signature

WORK ORDER 2006-12

Date opened: 8 September 2006

Project: Auxiliary Step Assembly  
Type: Bell 206L/407

Batch Quantity: 6 Assemblies

Approval: SH02-26  
Drawing List: DCL 623

Fabrication and Assembly Drawing(s)	Description
62320, Rev. 2	Step Assembly

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u> ✓
Document Control List revision level matches (or exceeds) STC:	<u>Y</u> ✓
Drawings revision levels match Document Control List:	<u>Y</u> ✓
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u> ✓
Tests and inspections specifically called out on drawings are complete:	<u>Y</u> ✓
Release tags associated with all fabricated parts are attached:	<u>Y</u> ✓
All mounting hardware and supplies are included:	<u>Y</u> ✓

List all non-conformities raised: WO2006-12/NC1

*REMAINING 5 ASSY*

<u>Jeff Chuke.</u>	<u>Sept. 27/06</u>
Inspector Signature:	Date:

PD FOR EACH PART

TEST + INSPECTIONS

RELEASE TAGS

HARDWARE

<u>Jeff Chuke.</u>	<u>June 4/07</u>
INSPECTOR SIGNATURE	DATE

Drawing: 62320 Revision 2

Qty	Part #	Description	Material	P.O./W.O.	Checked
6	62320-01	Step Assembly			
6	62320-03	Tube	4130 Steel 1.0 x 0.058 Round Tube	780626	
6	62320-04	Clamp	4130 Steel 2.5 x 0.065 Round Tube	951024A	
12	62320-05	Bushing	4130 Steel 0.375 x 0.058 Round Tube	970310	
6	62320-06	End Lug	4130 Steel 0.050 Sheet	3025	
12	62320-07	Pad	Commercial Neoprene Rubber	PRE-P.O.	
6	62320-08	Liner	6061-T6 Aluminum 2" Sched. 40 Pipe	5042	
12	MS21044N4	Nut		6016	
24	AN960-416	Washer		6016	
12	AN4-16A	Bolt		5039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	Drawing 62320	ER70S-2 Welding Rod		<i>David Smith</i>
Powder Coat	Drawing 62320	(6072) (7034)	<i>JFF</i>	<i>JFF Clark</i>
Final Inspection	Drawing 62320	(FIRST) (REMAINING) 5		<i>JFF Clark</i>

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

# NON-CONFORMANCE REPORT

Date: 11/09/2006  
DD / MM / YYYY

W.O. Number # 2006-12/NCI  
year - 000

## INSTRUCTIONS

1. Only a Design Approval Representative (DAR) is authorized to make a determination as to the regulatory impact of each non-conformance. A DAR must sign-off each non-conformance identified below before any further action can be taken.
2. ALL serialized products with an identified non-conformance must be listed.
3. Batched parts sharing the same non-conformance can be grouped on one form.
4. Print additional copies of this page as necessary to document all non-conformances and follow-up. ATTACH ALL NON-CONFORMANCE FORMS TO THE ORIGINAL WORK ORDER.

## DETERMINATION & ACTION

1. Product Name: Auxiliary Step Assembly
2. Product Serial Number(s): \_\_\_\_\_ OR
3. Batched Parts Item Number on WO: 62320-03 (Tube) and 62320-05 (Bushing)
4. Description of Non-Conformance (Attach additional page, photos, sketches if desired):  
Tube is 0.058 wall instead of 0.049 as specified on drawing.  
Bushing is 0.058 wall instead of 0.049 as specified on drawing.
5. Engineering Determination  
☐ Scrap  
☒ Acceptable for release for the following reason(s):  
Wall thickness is greater in both cases, does not reduce strength of part.  
☐ Re-Work instructions:

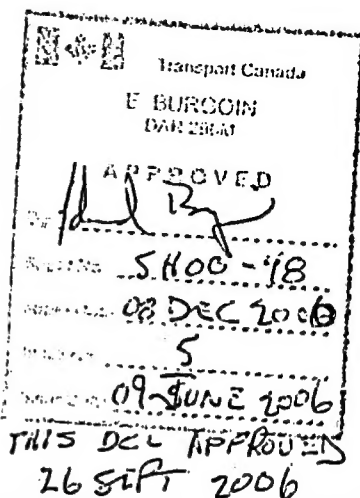
15/sep/06 [Signature]  
Date DAR's Signature

## RE-WORK INSPECTION & CERTIFICATION

I hereby certify that I have performed inspections on each of the above-named aeronautical product/part(s) and have found them to be in conformity to the Approved Design Data specified within the Scope of this Work Order, except where non-conformances have been specifically noted.

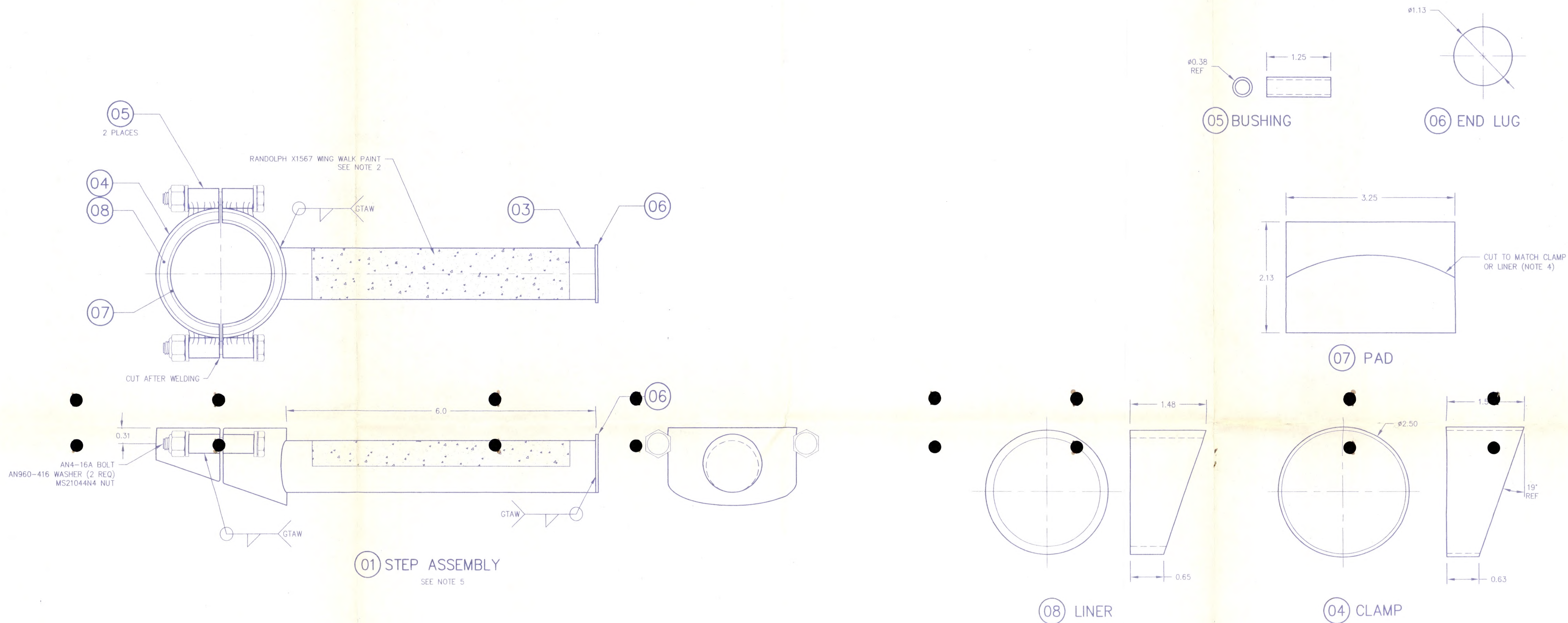
\_\_\_\_\_  
Date Inspector Signature

# DOCUMENT CONTROL LIST

DOCUMENT NO.	DOCUMENT CONTENT	REVISION
<b>INSTALLATION DOCUMENTS</b> 62301	Auxiliary Step Installation	1
<b>FABRICATION DOCUMENTS</b> 62320	Step Assembly	2
<b>ENGINEERING DOCUMENTS</b> ER623.01	Engineering Report	0
<b>APPROVAL:</b> 	ORIGINAL DATE: 13 January, 2005 REVISION DATE: 21 September, 2006	<b>AERO DESIGN LTD.</b> 2013 - 39 <sup>th</sup> Ave NE Calgary, Alberta T2E 6R7 Ph. (403) 250-8027 Fax. (403) 250-8333
	SHEET 1 OF 1	Bell 206L Series and 407 Auxiliary Step Installation
	<b>DCL623</b>	Rev. <b>1</b>



THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	LINER ADDED	BJC	JAN 13/05
2	ROTATION ANGLE CHANGED, SINGLE ASSEMBLY FOR LEFT/RIGHT	BJC	SEPT 8/06

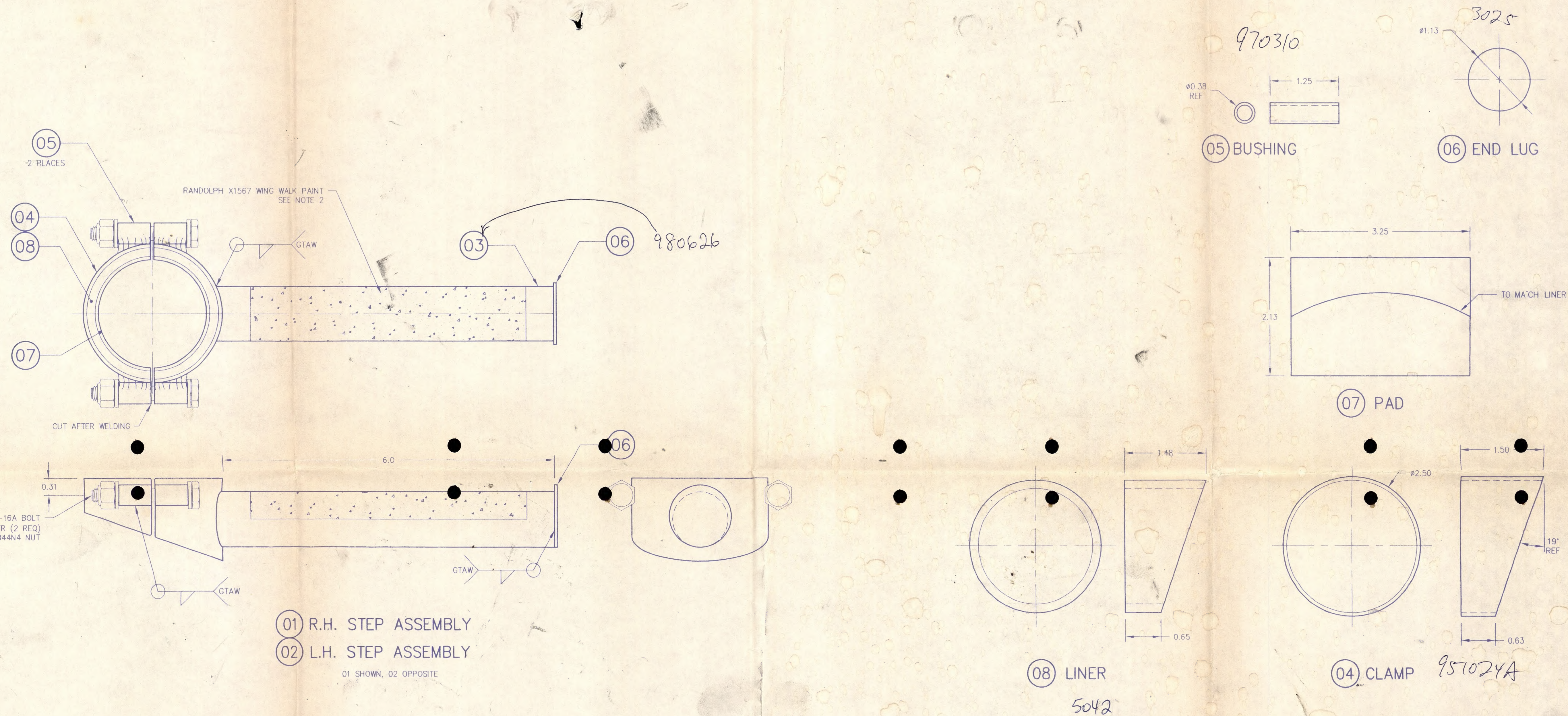


- NOTES:
- REMOVE ALL BURRS AND SHARP EDGES.
  - STEP ASSEMBLY TO BE THOROUGHLY DEGREASED AND POWDER COATED. PAINT RANDOLPH X1567 WING WALK GRIP PAINT ON TOP SURFACE OF TUBE.
  - WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR LATER REVISION.
  - ADHERE PAD (ITEM 07) TO LINER (ITEM 08) OR CLAMP (ITEM 04) USING CONTACT CEMENT. TRIM PAD TO MATCH.
  - TO ACCOMMODATE VARIATIONS IN ORIGINAL MANUFACTURER AND AFTERMARKET LANDING GEAR CROSS TUBES, THE LINER (ITEM 08) IS OPTIONAL. THICKNESS OF THE RUBBER PAD (ITEM 07) MAY VARY FROM 0.03" TO 0.13" AS REQUIRED.

2	AN4-16A	BOLT			
4	AN960-416	WASHER			
2	MS21044N4	NUT			
1	62320-08	08 LINER	6061-T6 AL PIPE	COMMERCIAL	2" SCHEDULE 40
1	62320-07	07 PAD	NEOPRENE RUBBER	COMMERCIAL	SEE NOTE 5
1	62320-06	06 END LUG	4130 STEEL COND. N	MIL-S-18729	0.050 SHEET
2	62320-05	05 BUSHING	4130 STEEL COND. N	MIL-T-6736	3/8 X 0.049 RND. TUBE
1	62320-04	04 CLAMP	4130 STEEL COND. N	MIL-T-6736	2.5 X 0.065 RND. TUBE
1	62320-03	03 TUBE	4130 STEEL COND. N	MIL-T-6736	1.0 X 0.049 RND. TUBE
	02				
	62320-01	01 STEP ASSEMBLY			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY	LIST OF MATERIALS				
			APPROVALS	DATE	
			DRAWN: JEFF CLARKE	13 AUG 2004	
			CHECKED: E. BURGAIN		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
			DECIMALS	ANGLES	
			X.XXX ±0.010	±1/2°	
			X.XX ±0.03		
			X.X ±0.1		
			AERO DESIGN LTD.		
			CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net		
			BELL 206L SERIES, 407 AUXILIARY STEP STEP ASSEMBLY		
			SCALE 1 : 1	DWG. SIZE	DWG. NO.
			SHEET 1 OF 1	A1	62320
					2



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REV.	DESCRIPTION OF CHANGE				INITIALS - DATE
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1	LINER ADDED				BJC JAN 13/05
2	ROTATION ANGLE CHANGED, SINGLE ASSEMBLY FOR LEFT/RIGHT				BJC SEPT 8/06



2	AN4-16A		BOLT			
4	AN960-416		WASHER			
2	MS21044N4		NUT			
1	62320-08	08	LINER	6061-T6 AL PIPE	COMMERCIAL	2" SCHEDULE 40
2	62320-07	07	PAD	NEOPRENE RUBBER	COMMERCIAL	0.06 THICK
1	62320-06	06	END LUG	4130 STEEL COND. N	MIL-S-18729	0.050 SHEET
2	62320-05	05	BUSHING	4130 STEEL COND. N	MIL-T-6736	3/8 X 0.049 RND. TUBE
1	62320-04	04	CLAMP	4130 STEEL COND. N	MIL-T-6736	2.5 X 0.065 RND. TUBE
1	62320-03	03	TUBE	4130 STEEL COND. N	MIL-T-6736	1.0 X 0.049 RND. TUBE
	62320-01	01	STEP ASSEMBLY			
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

	APPROVALS	DATE	AERO DESIGN LTD.			
	DRAWN: JEFF CLARKE	13 AUG 2004	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M			
	CHECKED: E. BURGOIN		2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
			tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES, 407 AUXILIARY STEP STEP ASSEMBLY			
		SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
		SHEET 1 OF 1	A1	62320	2	